

Date: Tuesday, 27/01/2009 11:11:58 AM  
User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLOWER MOTOR ADAPTER  
Job Number : 45283 - 1  
Estimate Number : 12133  
P.O. Number :  
This Issue : 27/01/2009 S.O. No. :  
Prsht Rev. : NC Part Number : D3476043  
First Issue : / / Type : SMALL / MED FAB Drawing Number : D3476 UNDER REVIEW  
Previous Run : 34440 Drawing Revision : A  
Material :  
Due Date : 15/02/2009 Qty: Um: Each  
Written By :  
Checked & Approved By : JUD 09.01.27  
Comment : Est Rev:A New Issue 06-01-31 JLM  
est rev B added comment @ # 5.0 06.11.01 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34763 Dome



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Qty Part Number Description Batch

1 D3476-3 blower motor adapter

B34492

FF 09-05-24

(6)

2.0 D34767 Tube



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Qty Part Number Description Batch

2 D3476-7 Tube

B47917

FF 09-05-24

(6)

3.0 D34761 Duct



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Qty Part Number Description Batch

1 D3476-1 Duct

B36162

FF 09-05-24

(6)

4.0 NAS1031C3W Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Qty Part Number Description Batch

4 NAS-1031C3W Nutplate

7107139

FF 09-05-24

(6)

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Spot Weld Tubes And Nut plates as per Dwg D3476 and Dart QSI 018

\*\*\*\*\* D3476-1 goes on top of D3476-3 \*\*\*\*\*

FF 09-06-01

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Tuesday, 27/01/2009 11:11:58 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 45283

Part Number: D3476043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 09/06/01 (6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/06/01 (X6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 09/06/01 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/01 (J)

Job Completion



MF  
09-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

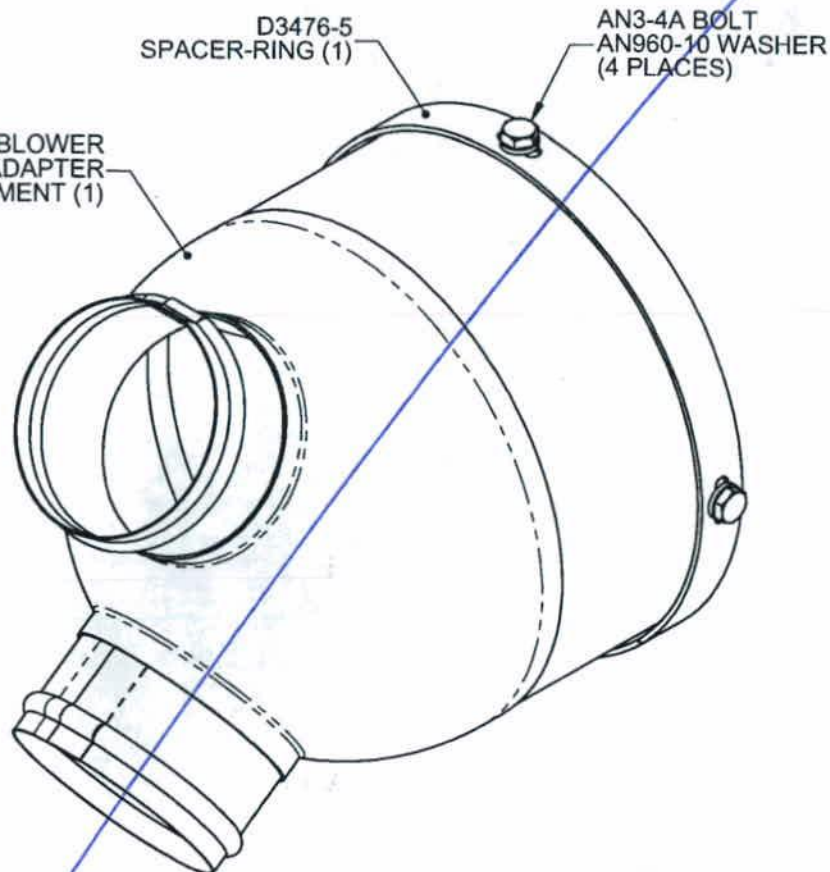
**NOTE:** Date & initial all entries

**DART**

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CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. <b>D3476</b>	REV. A SHEET 1 OF 7
DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:2
A	06.01.27	NEW ISSUE	

*06.04.03***UNDER REVIEW**

*02.09.03*  
Dial + manufacturing  
change

**D3476-041 BLOWER MOTOR ADAPTER**

- 1) IDENTIFY WITH DART P/N D3476-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3476-041	BLOWER MOTOR ADAPTER
1	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-5	SPACER-RING
4	AN3-4A	BOLT
4	AN960-10	WASHER

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WORK ORDER  
NO *45283*

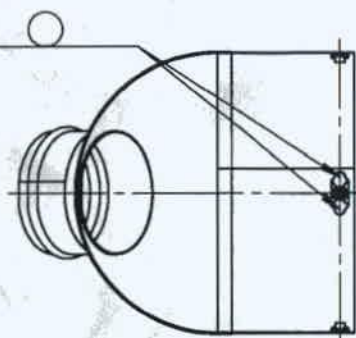
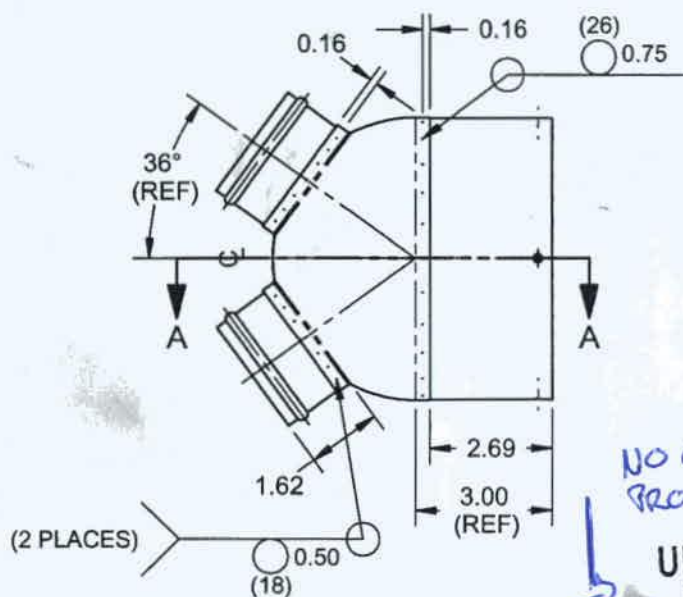
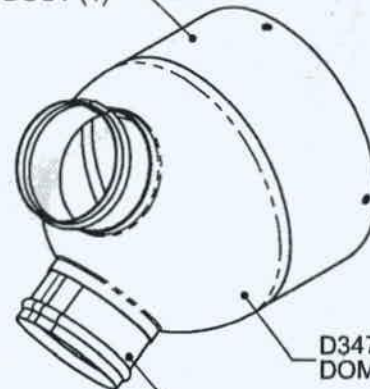
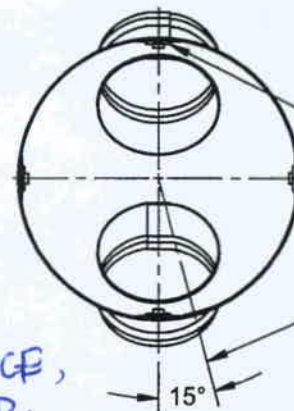
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DATE <b>06.01.27</b>	TITLE <b>BLOWER MOTOR ADAPTER</b> SCALE 1:4		

LOCATE AND  
SPOT WELD  
NUT PLATES  
(4 PLACES)**SECTION A-A**D3476-1  
DUCT (1)D3476-3  
DOME (1)D3476-7 TUBE  
(2 PLACES)NAS-1031C3W  
NUT PLATES  
(4 PLACES)OFFSET SEAM  
ON DUCTNO CHANGE,  
PROCEED.

UNDER REVIEW

02.04.23

Dirt + Manufacturing  
Change

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WITHOUT NOTICE

WORK ORDER

NO 45283

**D3476-043 BLOWER MOTOR  
ADAPTER WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

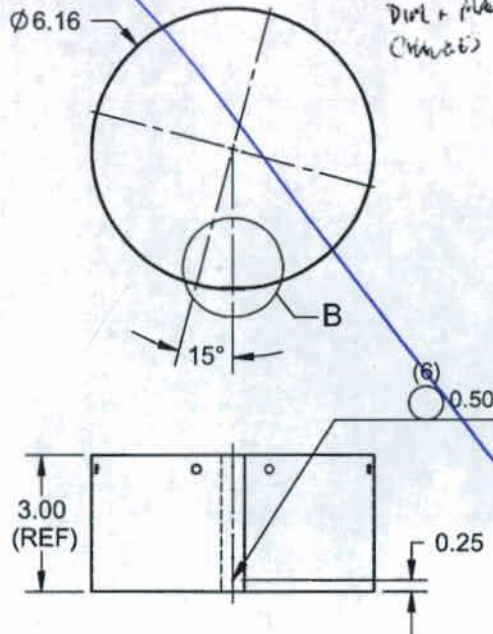
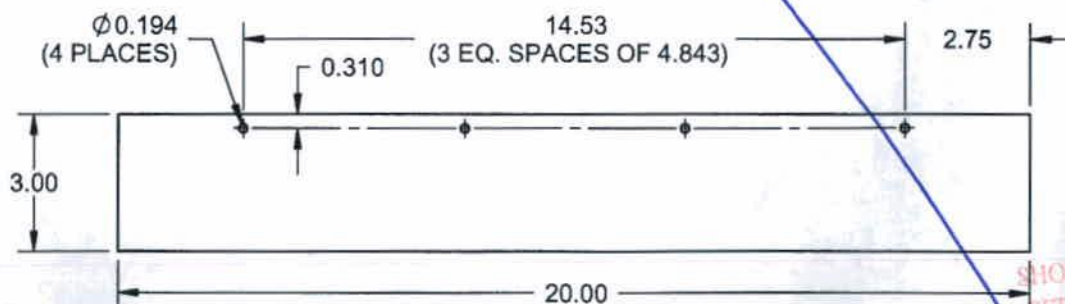
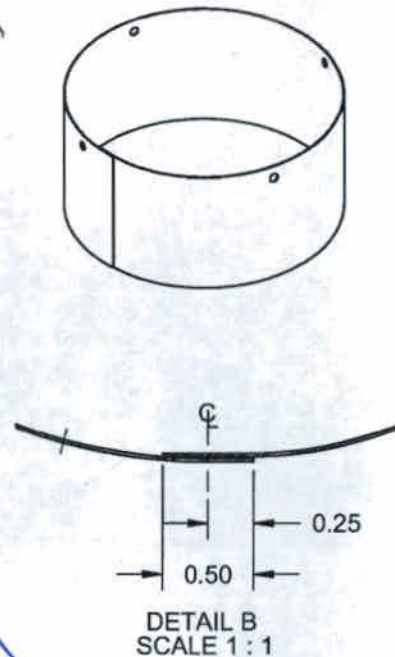
QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3476	REV. A SHEET 3 OF 7
DATE 06.01.27	TITLE BLOWER MOTOR ADAPTER		SCALE 1:4

**UNDER REVIEW***06.01.27**Dist. & identification  
(change)***D3476-1 DUCT****D3476-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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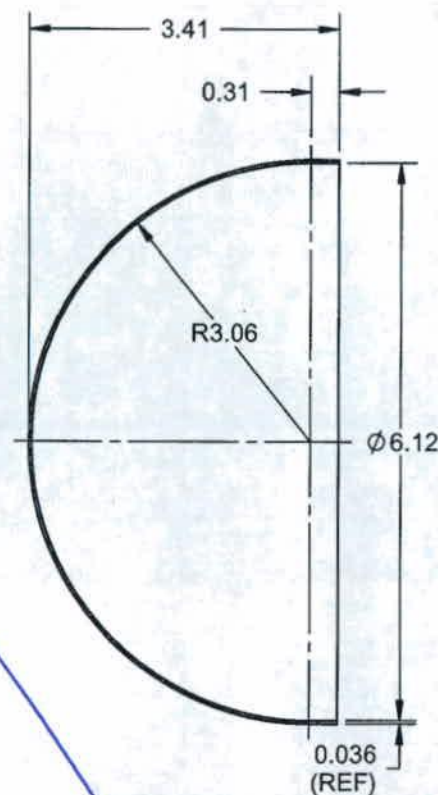
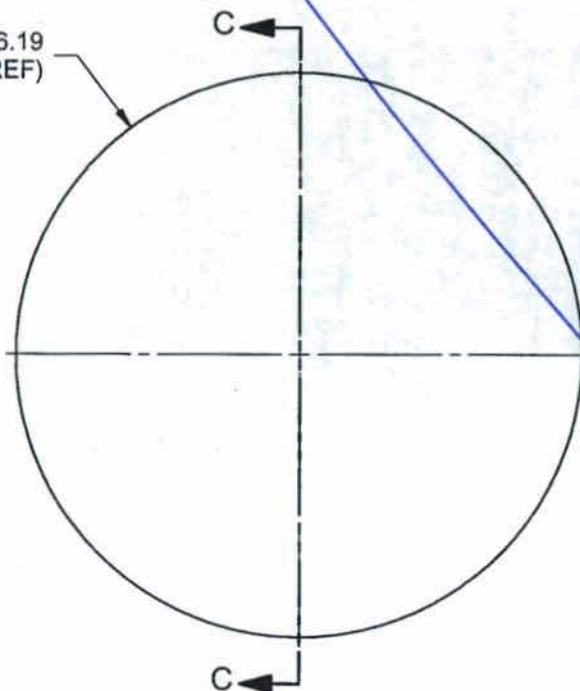
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DATE 06.01.27	TITLE BLOWER MOTOR ADAPTER		SCALE 1:2

RELEASED

06.04.03 *#*

UNDER REVIEW

02.09.03 *B*Dirt + Manufacturing  
ChangesØ6.19  
(REF)SECTION C-C**D3476-3S DOME, SPINNING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING OF MATERIAL (MINIMUM THICKNESS = 0.025").
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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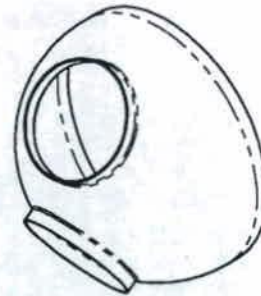
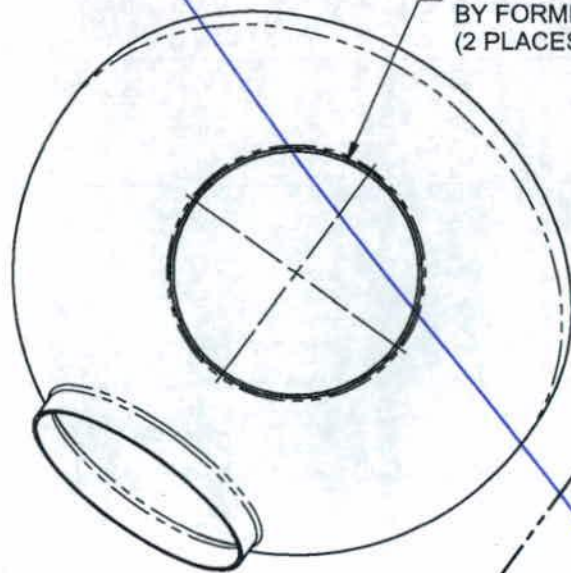


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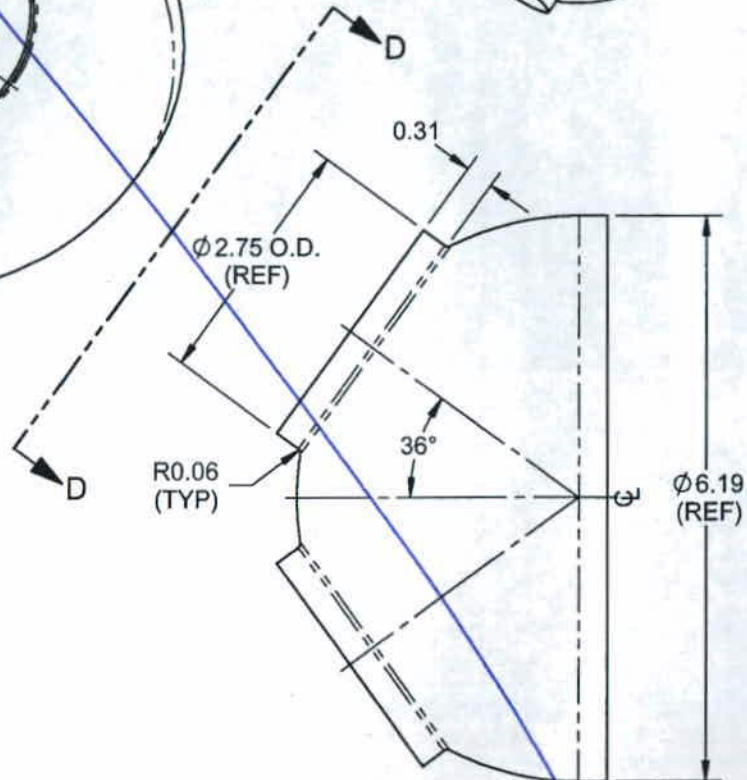
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DATE <b>06.01.27</b>	TITLE <b>BLOWER MOTOR ADAPTER</b> SCALE 1:2		

# 06.04.03

CUT  $\phi 2.25$  HOLE,  
ENLARGE TO  $\phi 2.68$   
BY FORMING FLANGE  
(2 PLACES)

**VIEW D-D****UNDER REVIEW**

07.04.03  
Dirt + fabrication  
(check)

**D3476-3 DOME****NOTES:**

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

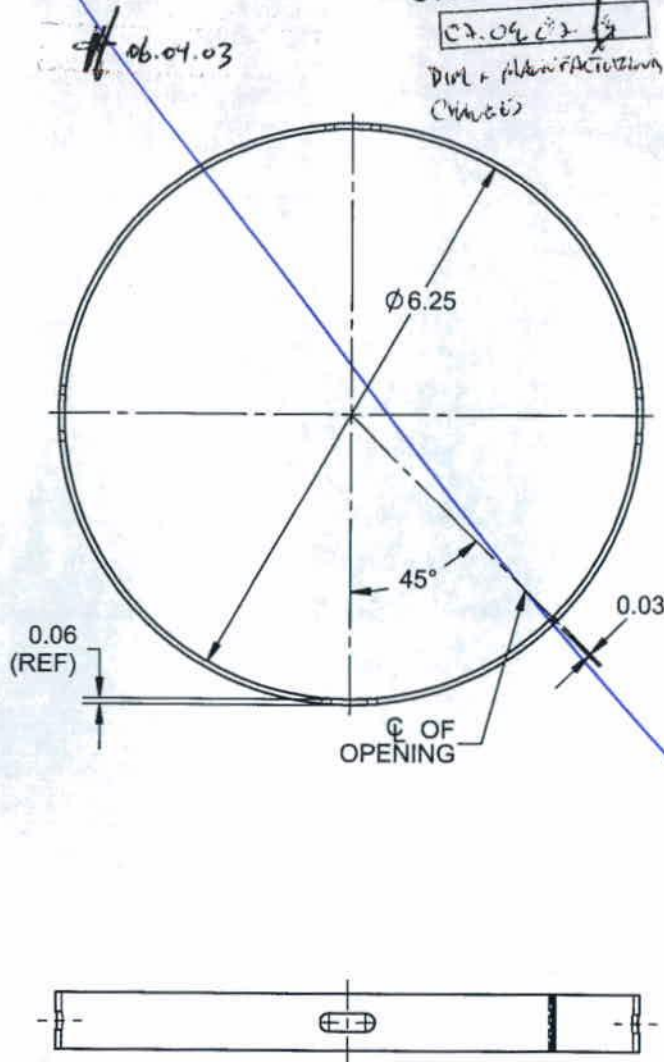
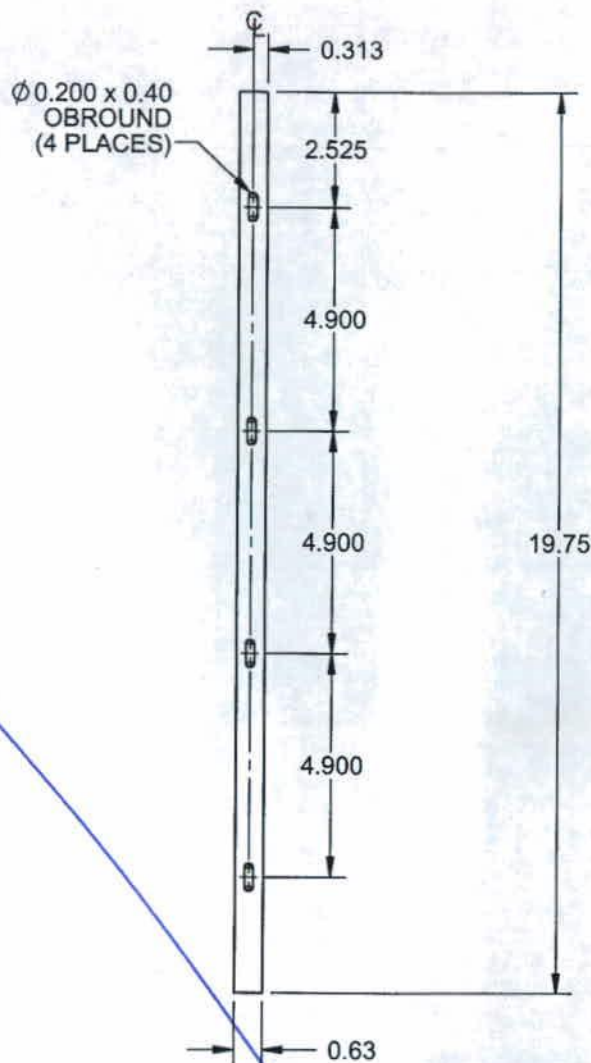
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DATE <b>06.01.27</b>	TITLE <b>BLOWER MOTOR ADAPTER</b> SCALE 1:2		

**UNDER REVIEW****D3476-5 SPACER-RING****D3476-5F SPACER-RING  
FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED)  
2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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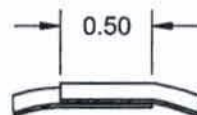
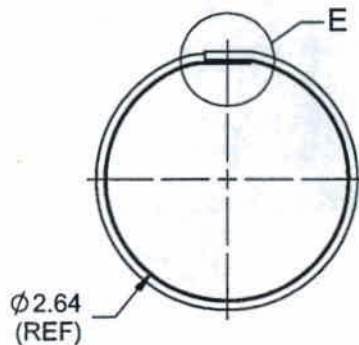
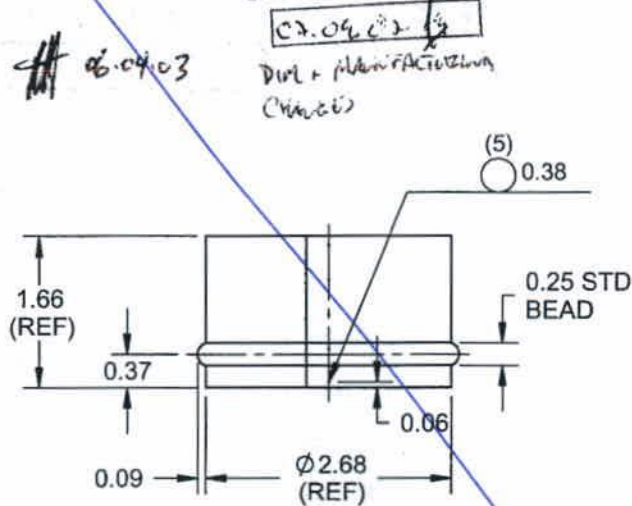
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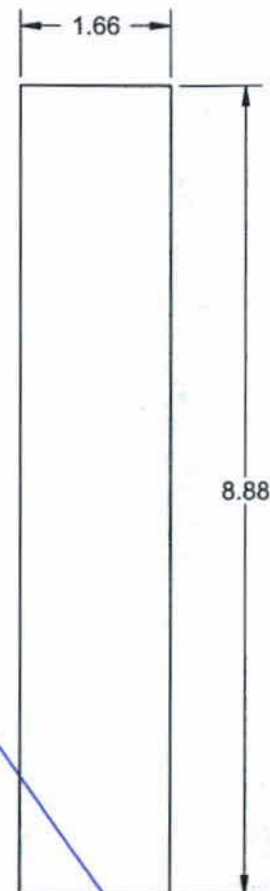


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DATE <b>06.01.27</b>	TITLE <b>BLOWER MOTOR ADAPTER</b>		SCALE 1:2

**UNDER REVIEW**

DETAIL E  
SCALE 1:1

**D3476-7 TUBE****D3476-7 TUBE  
FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**SPOT WELD TEST RECORD**  
**AMS-W-6858A**  
CLASS 'C'

**TEST NO#:** 67

**EMPLOYEE:** Franko Franko

**PART NUMBER:** D 3476-043

**JOB NUMBER:** TB 45203

**MATERIAL TYPE:** 304 L

**MATERIAL THICKNESS:** .018

**GROUP SPECIFICATION**

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium SS

**TEST RESULTS**

	PASS	FAIL	
VISUAL:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]	
PENETRATION:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]	
PULL STRENGTH:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]	PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

**DATE OF TEST COUPON:** 09/06/01

**QUALIFIER:** SB.